












Date: Wednesday, 18/02/2009 11:09:19 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 45869		
Estimate Number	: 13491		
P.O. Number	:	Part Number	: D37703
This Issue	: 18/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3770 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 42963	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 25/02/2009
Checked & Approved By	: <u>JUD 09.02.18</u>	Qty:	15
Comment	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
			
Comment: Qty.: 1.9031 f(s)/Unit Total : 28.5469 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M111029</u> <u>m-l 09/05/07</u>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		 (15X)	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to length as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 Using DT9412 3- deburr <u>m-l 09/06/07</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>S 09/05/11</u> (X15)			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		 (X15)	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>MD/BZ</u> <u>09/05/11</u>			
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		 (15)	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>FD</u> <u>09/05/12</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST254

88 09/05/12 (15)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-05-12

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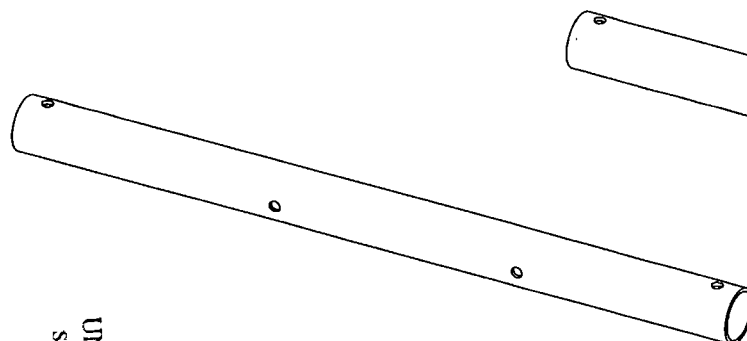
8 7 6 5 4 3 2 1

D

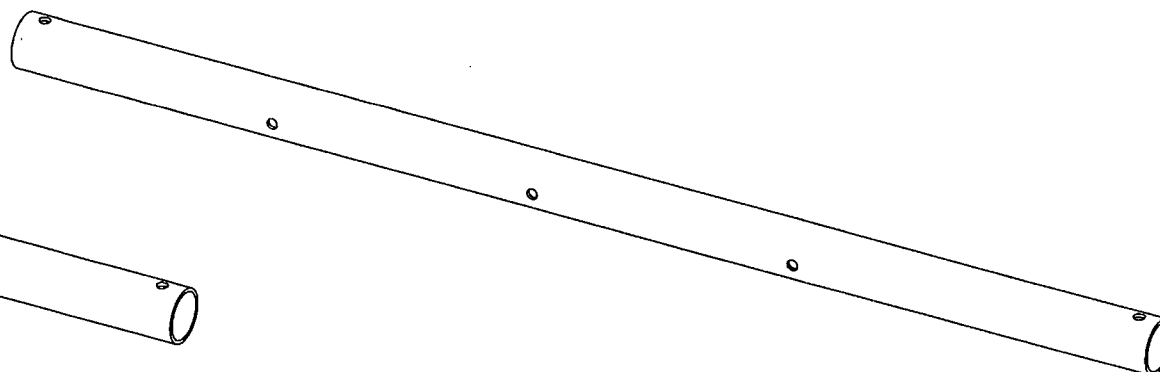
C

B

A



D3770-1 TUBE



D3770-3 TUBE

RELEASED
08.07.10

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3770	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	TUBE	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

A

D

C

B

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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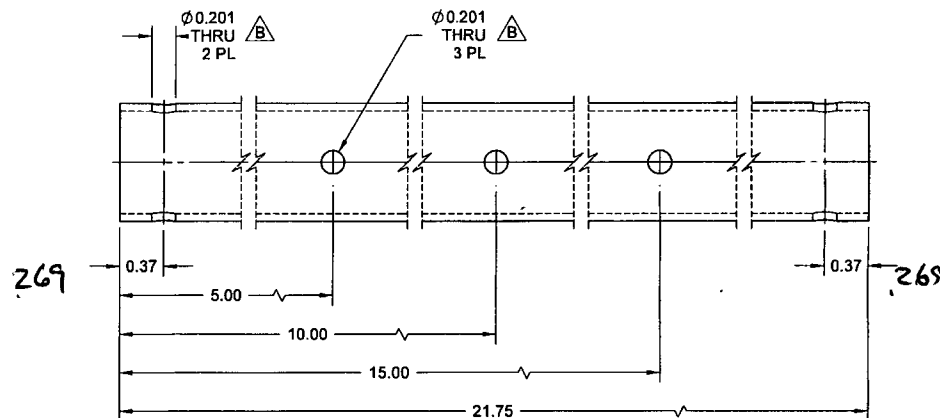
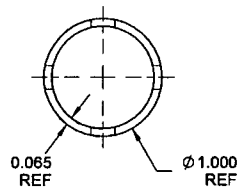
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D3770-3 TUBE

RELEASED
11/07/10

SHOP COPY
REF TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL

458629

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3770	REV. B
MFG. APPR.	HS	TITLE TUBE	SHEET 3 OF 3
APPROVED	HS	SCALE	NTS
DE APPR.	HS	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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